

Work Order ID 83576

Thursday, April 19, 2012 3:40:00 PM

83576

Page 1

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 4/19/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/18/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-04-09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2273	<i>R F</i>
D350-604-041	B <i>W</i>

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-604-041

0.00

DAS 16 9-53 12/04/13

CHG004

CHG004

ML5 12/03/13

110

0.00

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: ~~16555~~ 17583

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B *RT287*

4 x 2600-LW Retaining washers - Ship to Delastek B *N/A*

CL 12/09/23 ①
CL 12/09/11 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83576***83576***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

120

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs
Packaging

Memo

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

0.00

0.00

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Check hole locations to template. DT 8824 Check process sheet and audit.

0.00

0.00

140

140

Small Fab

Small Fab

Memo

INSTALL DECALS AS PER DWG

0.00

0.00

W/O: 83576

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 350-604-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/09/12		Found at inspection that the outside flange on Bottom of the Flange have too much Resin build up on it and	DAS 22 2-89 12/09/12	Grind off Build up + Re prime as per QZ 037.	07 2-89 12/09/12	DAS 15 2-89 17/09/13	U 12/09/12	DAS 16 2-89 17/09/13
		may interfere with the fit of the Rear Locks.		Re prime as per QZ 005 and obtain a smooth surface	AS 12-9-13			

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: SAPPP Rev: 7

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

DAP
16
12/9/13

12/9/13 SP

ML5 12-09-17

MM= 12-09-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 19, 2012 3:40:05 PM

Work Order ID: 83576

83576

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2269

Manufactured

No

Each

28.0000

1

D2269

Decal

**

80011

Location

Loc Qty

Loc Code

ST007

20

80011

20

ST009

8

78920

8

2600-6

Purchased

No

110

Each

131.0000

4

4

2600-6

Camlock Stud

**

CD 12/04/24 12/09/11

Location

Loc Qty

Loc Code

ST380

36

120077

36

ST381

95

121287

95

2600-LW

Purchased

No

110

Each

111.0000

4

4

2600-1 W

Camloc Retaining Washer

**

m 12/23/35 X 4

CD 12/09/11

Location

Loc Qty

Loc Code

ST381

100

121287

100

ST398

11

120648

11

m 12/524

X 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Page 2

Thursday, April 19, 2012 3:40:05 PM

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Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D350-604-041P

Purchased

No

110

Each

0.0000

1

1

D350-604-041P

Rear Locker Extender

83576 CU

D2268

Manufactured

No

140

Each

33.0000

1

1

D2268

Decal

88883 CU

Location

Loc Qty

Loc Code

ST007

20

80010

20

ST009

13

69592

2

78908

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

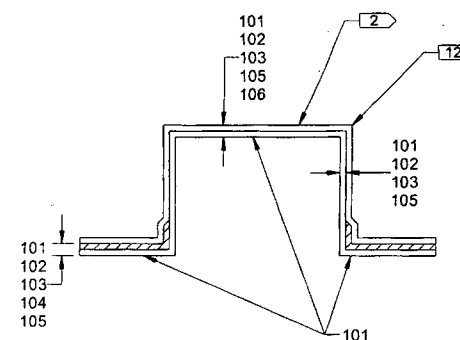
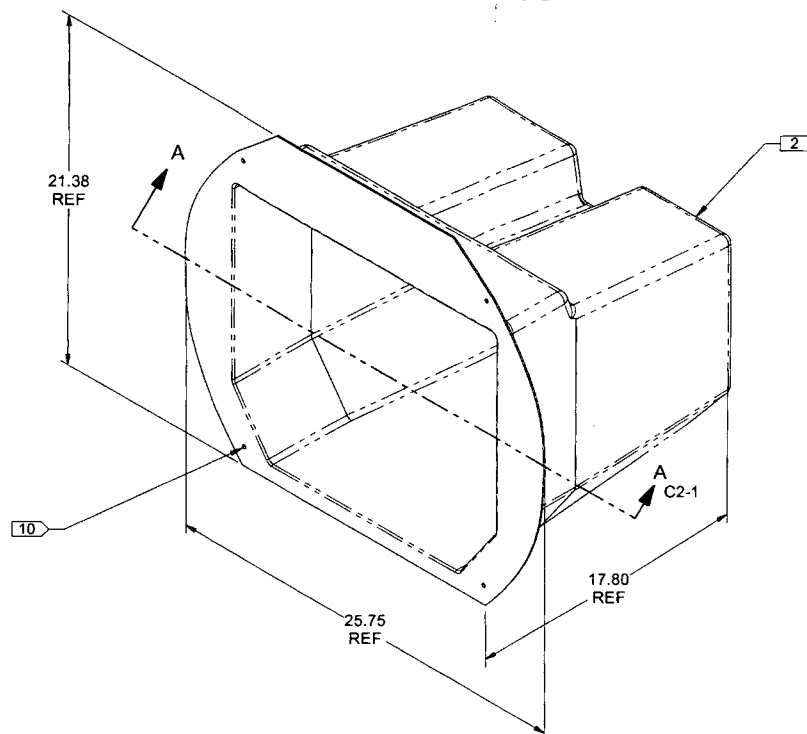
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83576

12-04-19



SECTION A-A
C4-1

RELEASED
2012-03-29

NOTES:

1) MATERIALS:

RESIN: DERA KANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS

2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S Δ

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 7.75 lbs

8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.

9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACCUUM

10) TRIM & DRILL PER DT8020. OPEN HOLES TO \varnothing 0.257 (4 PLACES)

11) CONSTRUCTION:

101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020

102-9 oz ALL OVER

103-18 oz ALL OVER

104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES

105-9 oz ALL OVER

106-PEEL PLY

12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

D2273 REAR LOCKER EXTENDER

F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST. ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2273 TITLE 350 REAR LOCKER EXTENDER SCALE NTS COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	12.02.27	REV. F SHEET 1 OF 1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April-03-12 1:38 PM
To: Daniel Campbell; 'Linda Lacelle'
Cc: Harvey Siemens; Chantal Lavoie
Subject: Re: ECN D2273

Dan,

I think Delastek is confused. Leave the dwgs for now ... I don't care whether we use Rev E primer or Rev F primer ... My understanding is that your Rev F dwg represents what is procurable going forward.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Daniel Campbell" <dcampbell@dartaero.com>
Date: Tue, 3 Apr 2012 10:42:39 -0600
To: 'Linda Lacelle' <llacelle@dartaero.com>; <dshepherd@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: ECN D2273

Hi,

I'm a little confused about this.

I thought we had checked back in Feb. and the 7704-S was discontinued and replaced with LE-3404-S / LE1175-S ?

Anyway, I can go back and update the following to call out 7704-S:

D604-350

1. D2273
2. ICA-D350-604

D605-206

1. D2566
2. ICA-D605-206

I'm not sure if David is flying today - we might have to wait for him to weigh in.

Thanks,
Dan

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April-03-12 10:00 AM
To: dshepherd@dartaero.com; Daniel Campbell
Subject: FW: ECN D2273

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]
Sent: April-03-12 11:30 AM
To: Linda Lacelle
Cc: 'Chantal Lavoie'; Céline Audet
Subject: ECN D2273

Hello Linda,

For the Gel Coat we are presently using N° 2330PAWK745, Gel Coat Polycore Fireblock and for the primer Dupont Primer N° 7704S. Thank you and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent

DELASTEK INC.

jlaurin@delastek.com

De : Linda Lacelle [<mailto:llacelle@dartaero.com>]
Envoyé : 2 avril 2012 14:54
À : Jocelyne Laurin; 'Chantal Lavoie'
Cc : David Paradis; Céline Audet
Objet : RE: ECN D2273
Importance : Haute

Jocelyne,

This is the current primer you are using. We need to understand exactly what you are currently using. Please DO NOT stop production on the parts to ship this Thursday.

L

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]
Sent: April-02-12 10:18 AM
To: 'Chantal Lavoie'; Linda Lacelle
Cc: David Paradis; Céline Audet
Subject: ECN D2273
Importance: High

Hello Chantal,

Before we can ship the rearlockers at rev. F, (for order attached), we have to analyse the implications, so the confirmed dates no longer stand, since they were for revision E. As soon as the analysis is completed we will forward a new quote (if applicable) as well as the new delivery dates, unless you want them at Rev. E. Please advise ASAP as they are being produced at the moment. Thank you so much and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent

DELASTEK INC.

jlaurin@delastek.com

De : Chantal Lavoie [<mailto:clavoie@dartaero.com>]

Envoyé : 30 mars 2012 10:38

À : Jocelyne Laurin

Cc : Lacelle, Linda

Objet : ECN D2273

Hi Jocelyne,

Please see attached for new revision for rearlocker they are now at rev. F.

Thanks

Chantal

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2012.0.1913 / Virus Database: 2114/4912 - Release Date: 04/03/12

Solve Composites

29 Distribution Way
Suite 101
Plattsburgh, NY 12901
Phone: 518-324-3838
Fax: 518-324-5530

Packing List

Bill Dart Aerospace

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 13527
Shipment Date: 09/10/12
Ship Via: Fedex Freight
Order Number: 11941
Order Date: 07/31/12

Customer Code: DART
Phone: (613) 632-9577
PO Number: 17583
Terms: Net 30 Days

Quantity				Unit	Description	Revision	Job Number
Open	Shipped	Back Ord	Canceled				
3	1	2		EA	D350-604-041P D350-604-041P Rear Locker Extender	F	11941-01

Packing Clerk's Initials
Solve Composites

Received In Good Order By
Dart Aerospace



Certificate of Conformance

Solve Composites

29 Distribution Way

Plattsburgh, New York, 12901

USA

Dart Aerospace Order Number: 17583

Part Number: D2273

Quantity: 1

Drawing Number: D2273, DT8020

Serial Number (s): 0026

Date: September 10, 2012

Non-Conformances: None

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

A handwritten signature in black ink, reading 'Jerry Reyell', written over a horizontal line.

Jerry Reyell

Project Manager

Solve Composites